

# Work Order ID 109720

November-28-13 8:08:13 AM

\*109720\*

Page 1

Item ID: D4667-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Armrest Stud Assembly  
 Start Date: 27/11/2013 Start Qty: 20.00 \*20\* Cust Item ID:  
 Required Date: 11/12/2013 Req'd Qty: 20.00 \*20\* Customer:  
 Reference: *[Signature]*

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4667	A

100	Hardinge CNC LATHE SMALL	0.00							
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\*100\*  
 Hardinge  
 Hardinge CNC Lathe Small  
 Memo  
 1- Turn D4667-1 as per Folio FB114 & Dwg D4667  
 Folio Rev: \_\_\_\_\_ Dwg Rev: A  
 2-Deburr  
*FK 13/11/29*  
 20 0

110	QC2- Inspect parts off machine FAI/FAIB	0.00							
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\*110\*  
 QC  
 Quality Control  
 Memo  
*FK 13/11/29*  
 20 0

120	QC8- Inspect parts - second check	0.00							
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\*120\*  
 QC  
 Quality Control  
 Memo  
*SN 13/11/29*  
 20 0

**\*109720\***

November-28-13 7:53:47 AM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 11/27/13      **Start Qty:** 20.00

**\*20\***

**Cust Item ID:**

**Required Date:** 12/11/13      **Req'd Qty:** 20.00

\*20\*

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date:

### Tooling:

Date:

Run Start \*NR1\*

**OC:**

Date:

**SPC (Y/N):**

Date:

Stop \*NR2\*

**Insp.**  
**Stamp**

0.00

**\*130\***

### Small Fab

## Memo

0.00

## Small Fab

INSTALL HELI-COIL AS PER DRAWING

140

QC5- Inspect part completeness to step on W/O

0.00

**\*140\***

OC

## Memo

0.00

## Quality Control

150

Identify as per dwg & Stock Location: W/A

0.00

**\*150\***

### Packaging

## Memo

0.00

## Packaging

**Work Order ID 109720**

November-28-13 7:53:47 AM

**\*109720\***

Page 3

Item ID: D4667-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Armrest Stud Assembly  
Start Date: 11/27/13 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 12/11/13 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

*[Handwritten signature]* 13/12/03

*11B-12-2*



# Picklist Print

November-28-13 7:53:46 AM

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Work Order ID: 109720

Parent Item: D4667-041

Parent Item Name: Armrest Stud Assembly

Start Date: 11/27/13

Required Date: 12/11/13

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A 12/06/11 as per dwg rev.PA1 JFS verf: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NR0.750 4130 steel RD bar .750"		Purchased	No			100	f	8.7160	0.12	3			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT031		8.716							
				111823		1.648							
				123772		7.068							
MS21209-F415 Heli-Coil		Purchased	No			130	Each	27.0000	1	20			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		27							
				123023		27							

2.54 F.K 13/11/29.  
FF 13-12-09

20



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

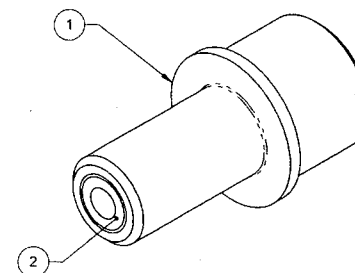
Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

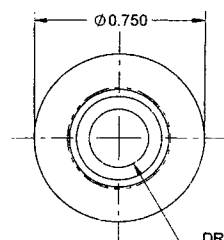
### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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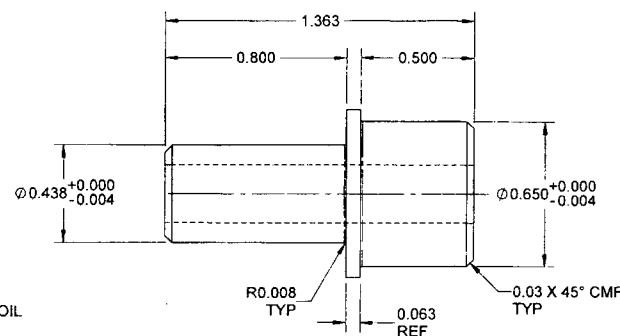
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4667-041	ARMREST STUD ASSEMBLY
1	1	D4667-1	ARMREST STUD
2	1	MS21209-F415	HELICOIL, LOCKING



**D4667-041 ARMREST STUD ASSY**



DRILL THRU Ø 0.261  
TAP FOR 0.250-28 HELICOIL  
0.45 DP



**D4667-1 ARMREST STUD**

109720 MJS  
13-11-27

**NOTES:**

- 1) MATERIAL -041: N/A  
-1: AISI 4130N ROUND BAR  
PER MIL-S-6758 OR AMS 6348/6370/6528  
REF M4130N-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

RELEASED  
2012-07-09  
PER ECN 1246

A	NEW ISSUE	AJS	12.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	SP	DRAWING NO.	REV. A
MFG. APPR.	SP	D4667	SHEET 1 OF 1
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	ARMREST STUD ASSEMBLY	NTS
DATE	12.06.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



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